Commodity Specification

CHICKEN CHUNKS IN WATER

JANUARY 2002

Table of Contents

Page

Page

I. GENERAL

Chicken chunks in water (commodity) produced from the classes of ready-to-cook boneless fowl chickens with or without skin described in this Specification will be packaged and packed in the following forms as specified in the contract:

29-Ounce Cans (211129) - The commodity will be packaged in 29-ounce (822-g) commercially acceptable cans and packed 24 cans in each fiberboard shipping container. A purchase unit will consist of 840 shipping containers totaling 36,540 pounds (16,574 kg).

50-Ounce Cans (211150) - The commodity will be packaged in 50-ounce (1.42-kg) commercially acceptable cans and packed 12 cans in each fiberboard shipping container. A purchase unit will consist of 1,000 shipping containers totaling 37,500 pounds (17,010 kg).

II. COMMODITY SPECIFICATIONS

A. Basic Requirements.

1. Date Processed. The commodity must not be processed and packaged more than 30 calendar days prior to the date of the contract.

2. Kind and Class. The commodity must be produced from ready-to-cook fowl (7 C.F.R. § 70.201 and II.B.1.).

3. Origin of Chicken. The commodity must be produced from chickens which were produced, raised, and processed in the United States, its territories or possessions, the Commonwealth of Puerto Rico, or the Trust Territories of the Pacific Islands. If the contractor processes or handles chicken products originating from sources other than the United States, its territories or possessions, Puerto Rico, or the Trust Territories of the Pacific Islands, the contractor must have an acceptable identification and segregation plan for these poultry products to ensure they are not used in the commodity produced under this Specification. This plan must be made available to a representative of the Grading Branch, Poultry Programs, Agricultural Marketing Service (AMS), United States Department of Agriculture (USDA) (grader), and the Contracting Officer or agent thereof upon request. The contractor must ensure that both the contractor and subcontractor(s) maintain records such as invoices, or production and inventory records evidencing product origin, and make such records available for review by the USDA grader or other Government official(s) in accordance with Article 76 of USDA-1.

4. Inspection. Processing operations must comply with Poultry Products Inspection Regulations (9 C.F.R. part 381) and be under the supervision of a representative of the USDA's Food Safety and Inspection Service (FSIS) (inspector). Inspection for contract and Specification compliance will be in accordance with the Regulations Governing the Voluntary Grading of Poultry Products and Rabbit Products (7 C.F.R. part 70) and the U.S. Classes, Standards, and Grades for Poultry (AMS 70.200 *et seq*.) under the supervision of a USDA grader. The USDA grader will be responsible for certification of compliance with the requirements of this Specification for ready-to-cook boneless chicken meat; chicken chunks; formulation of commodity; canned thermal-processed commodity; drained weight and net weight; packaging and packing; labeling and marking; sampling; and checkloading.

II.A.

5. FSIS Requirements. **The commodity must be produced and processed in an FSIS Federally inspected establishment, be accurately marked and/or labeled, and meet all FSIS regulatory requirements, including all microbiological testing requirements, currently in place.**

6. Product Temperature. The temperature of chicken and chicken products and cooked chicken meat and skin, unless otherwise specified herein, must be in compliance with FSIS regulations and directives and this Specification throughout all operations including transportation between plants.

7. Chicken From Other Plants. Frozen and chilled chicken and chicken products may be transferred or obtained from other plants, provided they: (a) have been processed, handled, and identified in accordance with this Specification, and (b) comply with the organoleptic and other applicable requirements of this Specification as evidenced by USDA certification.

a. Type, kind, and class of chicken; date slaughtered or date placed in frozen storage, as applicable; and USDA-assigned plant number must be shown on each shipping container.

b. The chicken and chicken products must be at an internal product temperature not higher than 40 °F (4.4 °C) when shipped from the origin plant and when received at the destination plant.

8. USDA Sampling Option. USDA may select additional product for further inspection or may draw samples for laboratory analyses.

B. Prerequisites for Meat and Skin

1. Acceptable Meat.

a. Light Fowl. White and dark meat from ready-to-cook light fowl or spent hens may be used. Light fowl is defined under this Specification as fowl (7 C.F.R. § 70.201) carcasses weighing 4.50 pounds (2.04 kg) or less each.

b. Heavy Fowl. Only dark meat from ready-to-cook heavy fowl or baking/stewing hens may be used. Heavy fowl is defined under this Specification as fowl (7 C.F.R. § 70.201) carcasses weighing more than 4.50 pounds (2.04 kg) each.

c. Meat. Meat must be boneless and skinless.

(1) Ready-to-cook meat. Ready-to-cook chilled bone-in meat and boneless meat may be used if it is: (a) deboned and used in the commodity within 7 calendar days after the chickens are slaughtered, and (b) chilled in accordance with FSIS requirements.

(2) Frozen meat. Frozen bone-in meat and boneless meat may be used if it has been: (a) packaged to protect the product from freezer burn, dehydration, and quality

deterioration during storage; (b) labeled as to kind and class of chicken and identified so the time in storage can be determined; and (c) held in frozen storage not more than 60 days.

d. Meat percentages.

(1) The following percentages of meat (II.B.1.a. and b.) must be used under this Specification:

Boneless, Skinless White Meat from Light Fowl (Spent Hens)	50.00 - 65.00
Boneless, Skinless Dark Meat (maximum) from Light and Heavy Fowl	35.00 - 50.00

(2) The contractor must have established control procedures, processing sequence, product flow, and methods for handling the boneless, skinless white and dark meat to ensure the identification of white meat from light fowl and dark meat from heavy fowl prior to formulation.

2. Unacceptable Meat. Mechanically separated meat (comminuted), giblets, and kidneys cannot be used in preparing the commodity.

3. Skin.

a. Skin must be removed from chilled or frozen meat.

b. If used, the skin must not exceed 12 percent of the formulated commodity. The amount of skin may be reduced and replaced with additional white meat or dark meat (in accordance with II.B.1.d.).

4. ORGANOLEPTIC REQUIREMENTS. THE MEAT and skin WILL BE EXAMINED ON A CONTINUOUS BASIS FOR THE FOLLOWING ORGANOLEPTIC REQUIREMENTS: MEAT AND SKIN MUST BE FREE OF RANCIDITY; FREE OF FRUITY, SULFIDE-LIKE, CARDBOARDY, TALLOWY, OILY, OXIDIZED, METALLIC, CHLORINE, OR OTHER OFF-ODORS; FREE OF FOREIGN MATERIALS [E.G., GLASS, PAPER, RUBBER, METAL]; MUST SHOW NO EVIDENCE OF MISHANDLING OR DETERIORATION; AND MUST HAVE A BRIGHT COLOR AND SHOW NO EVIDENCE OF FREEZER BURN OR DEHYDRATION, THAWING, OR REFREEZING. ANY SAMPLE OF MEAT THAT DOES NOT COMPLY WITH THE ORGANOLEPTIC REQUIREMENTS WILL BE REJECTED FOR USE UNDER THIS SPECIFICATION.

C. PROCESSING, FORMULATION, AND REQUIREMENTS FOR COMMODITY

1. PROCESSING SEQUENCE. UNLESS OTHERWISE SPECIFIED, BONE AND SKIN REMOVAL FROM THE MEAT, MARINATING, COOKING, SIZE REDUCING, FORMULATING, MIXING, CANNING, AND THERMAL PROCESSING MUST BE A CONTINUOUS PROCESS THAT COMPLIES WITH THE TEMPERATURE REQUIREMENTS OF THIS SPECIFICATION.

II.

2. Marinating. The boneless, skinless white and dark meat must be marinated in a solution of water, salt, food starch, and sodium phosphate by tumbling, massaging, or injecting before cooking.

a. The marinating solution must not exceed 15 percent (increase weight of the marinated meat and skin by a maximum of 15 percent over the original ready-to-cook weight). The marinating solution (marinade) will consist of the following ingredients in accordance with the maximum percentages shown:

	Formulated
Water (maximum)	81.67
Food starch (maximum)	10.00
Salt (maximum)	5.33
Phosphate (maximum)	3.00
	100.00%

b. Amount of restricted phosphates must comply with FSIS requirements.

c. Marinated meat that does not comply with the requirements will be rejected for use under this Specification.

3. Cooking.

a. Marinated meat without giblets must be cooked with water or steam without pressure. The method of cooking must produce a cooked product free of overcooked, burnt, scorched, bitter, metallic, cardboardy, rancid, or other flavors or odors foreign to properly cooked chicken.

b. The cooked meat must be handled and cooled in accordance with FSIS regulations and directives and this Specification. Cooked meat may be held at 40 °F (4.4 °C) or lower for not more than 5 days from time of cooking until canned, or the chilled cooked meat may be frozen and held at an internal product temperature of 0 °F (-17.8 °C) or lower.

4. Cooked Meat and Skin Defects.

a. Organoleptic defects. The cooked meat will be examined on a continuous basis for compliance with the organoleptic requirements shown in Table 1. If the cooked meat does not comply with the organoleptic requirements, it will be rejected for use under this Specification.

b. Skin defects. Before the skin is reduced in size, a 2-pound (0.91 kg) sample of skin will be examined for the skin defects shown in Table 1. The frequency of sampling will be as outlined in Poultry Programs' Sample Plan Level 2 (SPL-2). If any sample of skin has more defects than the maximum tolerance for the sample plan, the skin the sample represents will be rejected.

Table 1. Cooked Meat and Skin Defects

Organoleptic Defects:	**The meat and skin must be free of** foreign materials (e.g., glass, paper, rubber, metal); and odors which are not characteristic of properly cooked and handled poultry meat; for example, rancid, metallic, stale, sour, or scorched.
Skin Defects:	**A defect for skin is the presence of** feathers, hair, leaf fat, and areas of moderate discolorations exceeding an area equivalent to the area of a circle with a diameter of 1 inch (2.54 cm).

5. Size Reduction of Meat and Skin.

a. Skin. When used, cooked skin must be reduced in size to pieces no greater than 0.25 inch (1/4 inch) (0.64 cm) in maximum dimension before it is used in the commodity.

b. Meat. Larger pieces of cooked marinated meat, to include breast portions and thigh portions, must be cut into chunks which are a minimum of 1.00 inch (2.54 cm) in size. The meat must be processed in a manner that will minimize stringy texture.

6. Formulation. The following proportions of ingredients must be used in preparing the finished commodity:

	Percent by Weight
Cooked, Marinated, Boneless, Skinless Size-Reduced White and Dark Chicken Meat (see II.B.1.d.)	80.00 - 100.00
Skin (maximum)	12.00
Water (maximum)	8.00
	100.00

7. Mixing. The cooked, marinated white meat, dark meat, and the cooked skin (as applicable) must be mixed. The meat must not be ground or shredded.

8. Packaging. All packaging materials must be clean and in new condition and must not impart odors or flavors to the product. A supplier of packaging material must furnish a guaranty that the packaging material complies with FSIS REQUIREMENTS.

II.C.8.

a. Packaging material. The commodity must be packaged in cans. The cans must be metal, round, and equivalent to those in commercial use.

b. Filling cans. Cans may be filled by first adding the homogenous mixture of cooked formulated meat and skin (as applicable) to each can and then adding water (as applicable) to each can, or filling with a homogenous mixture of cooked formulated meat, and skin and water (as applicable).

(1) 29-ounce cans. Twenty-nine ounces (822 g) net weight of commodity must be packed in commercially acceptable cans.

(2) 50-ounce cans. Fifty ounces (1.42 kg) net weight of commodity must be packed in commercially acceptable cans.

9. Net Weight. The net weight of the commodity will be determined in accordance with Poultry Programs' procedures.

D. Thermal Processing

The filled can must be vacuumized, hermetically sealed, and thermal-processed in accordance with FSIS regulations. The thermal-processed commodity must have a stable shelf-life under the conditions of long-term, nonrefrigerated storage and transportation. The exterior of the can must be dry, clean, and free from rust, fat, and grease before packing into shipping containers.

E. Lots, Sublots, and Sampling

1. Definition of a Lot.

a. A lot is defined as the amount of commodity produced during a processing shift.

b. Unless otherwise specified, the commodity will be: (1) sampled, examined, and tested; and (2) accepted, rejected, or accepted subject to a price discount on a lot basis.

2. Definition of a Sublot.

a. A lot may be separated into sublots for the purpose of sampling and analyzing for compliance with the fat requirements. Additionally, lots may be separated into sublots for the purpose of sampling and determining drained weight and compliance with organoleptic and commodity defect requirements. If this option is used, the commodity must be sampled as outlined in II.E.3. below.

b. Commodity sampled and analyzed on the basis of sublots will be accepted, rejected, or accepted with a discount on a sublot basis.

3. Definition of a Sample.

a. A sample is one 29-ounce or 50-ounce (822-g or 1.42-kg) can of commodity or its equivalent.

b. The USDA grader will draw samples at random for compliance with the organoleptic requirements, and determination of fat content and drained weight after thermal processing. As determined by the contractor/processor, the USDA grader will collect sample cans from each lot or sublot at random **prior to** or **after** thermal processing to examine for the commodity defects (see II.F.5.). The contractor/processor must select a sampling option (either option I or option II) prior to the start of production.

(1) If the contractor/processor elects to sample cans **prior to** thermal processing (option I), the number of samples from a lot for the fat analyses, drained weight, and the determination of organoleptic and defect requirements will be as detailed in Table 2.

(a) For the determination of organoleptic and defect requirements under option I, no additional separation of the lot into sublots will be allowed.

(b) Samples for organoleptic requirements (see II.F.4.), fat content requirements (see II.F.1.), and drained weight determination (see II.F.3.) will be drawn after thermal processing and will represent 1 day's production.

Table 2. Samples Drawn Online From a Lot or Sublot - *Option I*

	29-ounce (822-g) cans				50-ounce (1.42-kg) cans		
Lot or Sublot	**Organoleptic and Defect Requirements**	**Fat Analyses**	**Drained Weight**	**Lot or Sublot**	**Organoleptic and Defect Requirements**	**Fat Analyses**	**Drained Weight**
Lot	2 cans per sampling interval	10 cans	10 cans	**Lot**	1 can per sampling interval	6 cans	6 cans
Sublot	2 cans per sampling interval	5 cans *	5 cans *	**Sublot**	1 can per sampling interval	3 cans *	3 cans *

* The total number of samples drawn from all sublots in a lot must be equal to or greater than those specified for a lot.

II.E.3.

(2) If the contractor/processor elects to sample cans **after** thermal processing (option II), the sampling of commodity from a lot or a sublot will be as detailed in Table 3 below:

Table 3. Samples Drawn From a Lot or Sublot - *Option II*

29-ounce (822-g) cans				**50-ounce (1.42-kg) cans**			
Lot or Sublot		**Drained Weight**	**Organoleptic and Defect Requirements**	**Lot or Sublot**		**Drained Weight**	**Organoleptic and Defect Requirements**
Total No. of Cans	**Fat Analyses**	**Number of Cans**		**Total No. of Cans**	**Fat Analyses**	**Number of Cans**	
Lot		First 10 cans	First 10 + 6 cans	**Lot**		First 6 cans	First 6 + 2 cans
Total = **26** cans	10	16 cans total		Total = **14** cans	6	8 cans total	
Sublot *		First 5 cans	First 5 + 3 cans	**Sublot** *		First 3 cans	First 3 + 1 can
Total = **13** cans	5	8 cans total		Total = **7** cans	3	4 cans total	

* The total number of samples drawn from all sublots in a lot must be equal to or greater than those specified for a lot.

F. Requirements for Thermal-Processed Commodity

1. Fat Content. After thermal processing, the USDA grader will randomly draw sample cans (as defined in II.E.3.b.) for laboratory analyses for fat content. The samples will be analyzed in a USDA laboratory. A lot or sublot of thermal-processed commodity must contain no more than an average 9.5 percent fat. Contractors may choose to participate in the Contractor Analysis of Fat Content Program in II.H.

2. Price Discounts.

a. A lot or sublot of thermal-processed commodity with more than 9.5 percent fat (average for the lot or sublot) but not more than 10.5 percent fat will be accepted with the following deviations subject to the price discount indicated:

Fat Content, Basis USDA Laboratory Analysis	Applicable Discount
Greater than 9.5 but not more than 10.0 percent	2.00 percent of contract price
Greater than 10.0 but not more than 10.5 percent	4.00 percent of contract price

b. A lot or sublot of thermal-processed commodity with more than 10.5 percent fat will be rejected.

3. Drained-Weight Requirements and Determination.

a. Samples. After thermal processing, the USDA grader will randomly draw sample cans (as defined in II.E.3.b.) to determine drained weight.

(1) Filled 29-ounce can requirements. The 29-ounce (822-g) filled cans from a lot or sublot must average not less than 19.2 ounces (544 g) of commodity on a drained-weight basis.

(2) Filled 50-ounce can requirements. The 50-ounce (1.42-kg) filled cans from a lot or sublot must average not less than 33 ounces (0.94 kg) of commodity on a drained-weight basis.

(3) Discounts. Lots or sublots of commodity with a drained weight averaging: (1) greater than or equal to 18.2 ounces (516 g) and less than or equal to 19.2 ounces (544 g) for 29-ounce cans (822-g), or (2) greater than or equal to 31.5 ounces (0.89 kg) and less than 33 ounces (0.94 kg) for 50-ounce (1.42-kg) cans will be accepted with the following deviations subject to the price discount indicated in Table 4.

(4) Rejections. A lot or sublot of filled cans with a drained weight averaging less than the weights indicated in Table 4 will be rejected.

Table 4. Drained Weights and Discounts

Drained Weight Basis Average for Lot or Sublot	Applicable Discount (Percent of Contract Price)	Rejected Lot or Sublot
29-ounce (822-g) cans		
Greater than 18.7 oz. (530 g) and less than 19.2 oz. (544 g)	2.25 percent	Average less than 18.2 oz. (516 g)
Greater than or equal to 18.2 oz. (516 g) and less than or equal to 18.7 oz. (530 g)	4.50 percent	
50-ounce (1.42-kg) cans		
Greater than 32 oz. (0.91 kg) and less than 33 oz. (0.94 kg)	2.25 percent	Average less than 31.5 oz. (0.89 kg)
Greater than or equal to 31.5 oz. (0.89 kg) and less than or equal to 32 oz. (0.91 kg)	4.50 percent	

II.F.3.

c. Determination. The drained-weight of the sample cans will be determined 24 to 72 hours after the day of the processing shift in which the product was produced. The contents of each sample can will be weighed after draining product with a No. 8 sieve, for 2 minutes for a 29-ounce (822-g) can and 3 minutes for a 50-ounce (1.42-kg) can. The temperature of the commodity at time of weighing must be 75 ° ± 5 °F (23.9 ° ± 2.8 °C). The average drained-weight results will be reported to the nearest 10th of an ounce on the USDA shipping certificate.

d. Rejected product. If the commodity in a lot or sublot is rejected for drained weight, the contractor/processor may request an appeal which must be performed within 6 calendar days from the end of the processing shift on which the product was produced. The contractor/processor may remove cans suspected of being out of compliance and reoffer the balance of the lot or sublot once for acceptance. Those cans determined out of compliance with drained weight requirements will be rejected, but may be reworked in accordance with II.F.6.

4. Organoleptic Requirements. After thermal processing, the commodity will be sampled (as defined in II.E.3.) and examined for compliance with the following organoleptic requirements: The commodity must have an appetizing appearance, odor, flavor and texture, and must be free of off-flavor or off-odors; for example, overcooked, burnt, scorched, sour, stale, cardboardy, metallic, bitter, or rancid. A lot or sublot of commodity which does not comply with these organoleptic requirements will be rejected for use under this Specification.

5. Commodity Defects. The contractor/processor may select one of the two options below for the examination of commodity defects. Once an option is selected, the contractor/processor may not change options until the end of 1 day's production. Samples of commodity with more defects than the maximum tolerance for either option will result in the rejection of the lot or sublot the samples represent.

a. Option I - Examination **prior to** thermal processing. The samples (see II.E.3.b.(1) for sampling) will be randomly selected online prior to canning or thermal processing and examined for the defects shown in Table 5.

(1) The number of defects allowed will be those outlined in Poultry Programs' Sample Plan Level 2 (SPL-2). Separate examinations will be made for: (1) bone and (2) other defects.

(2) Regardless of the kind and number of defects (within Table 5) found, any sample with bone or hard bone-like material greater than 0.50 inch (1.27 cm) will be cause for the rejection of the product the sample represents.

(3) If the number of bone defects exceeds the maximum for the "target" level for the respective defect, or results in a rejection, the frequency of sampling for bone defects will be increased to a sample drawn twice each sampling interval until the cumulative number of bone defects reverts back to the "target" level.

(4) If the sample has more defects than the maximum tolerance for the sample plan, the product the sample represents will be rejected.

Table 5. Commodity Defects - *Option I*

Meat Defects:	**A defect for meat is the presence of:**
Bone:	Bone or hard bone-like material in a sample greater than 0.50 inch (1.27 cm) (II.F.5.a.(2)). Bone or hard bone-like material in a sample less than or equal to 0.50 inch (1.27 cm).
Other:	Dark colored (due to blood) vein or artery more than 1 inch (2.54 cm) in length. Bruises, blood clots, and moderate discolorations which exceed an area equivalent to a circle with a diameter of 0.30 inch (0.76 cm).

b. Option II - Examination **after** thermal-processing.

(1) After drained weight determination, the samples (see II.E.3.b.(2) for sampling) will be examined for the defects shown in Table 6.

(2) Separate examinations will be made for: (1) bone and (2) other defects. The number of defects allowed in a sample representing a lot or sublot will be as shown in Table 6.

(3) Regardless of the kind and number of defects (within Table 6) found, any sample with bone or hard bone-like material greater than 0.50 inch (1.27 cm) will be cause for the rejection of the product the sample represents.

(4) If the sample has more defects than the maximum tolerance for the sample plan, the product the sample represents will be rejected.

II.F.5.

Table 6. Thermal-Processed Commodity Defects Allowed - *Option II*

	Criteria	Tolerance
Meat Defects:	**A defect for meat is the presence of:**	
Bone:	Bone or hard bone-like material * in a sample greater than 0.50 inch (1.27 cm).	**See II.F.5.b.(3)**
	Bone or hard bone-like material * in a sample less than or equal to 0.50 inch (1.27 cm).	6 bones permitted per lot 3 bones permitted per sublot
Other:	Dark colored (due to blood) vein or artery more than 1 inch (2.54 cm) in length. Bruises, blood clots, and moderate discolorations which exceed an area equivalent to a circle with a diameter of 0.30 inch (0.76 cm).	10 defects permitted per lot 5 defects permitted per sublot

* Bone or hard bone-like material is material which does not break up or disintegrate when subjected to pressure from a spatula, flat side of a knife, or fork.

6. Reworked Commodity.

a. Sample cans examined by the USDA grader and product rejected for defects exceeding the maximum tolerances, drained weight, or fat content may be reworked and incorporated into formulated batches of cooked product, prior to thermal processing, provided:

(1) The defects are removed from the product;

(2) The product is incorporated at a maximum of 5 percent of the formulated batch; and

(3) Product removed from cans must be reworked into a batch within 72 hours.

b. X-ray equipment may be used to examine product to be reworked provided:

(1) The equipment and x-ray examination procedures are found to be in compliance with FSIS regulations and procedures; and

(2) A USDA grader monitors the x-ray and rework procedure.

(3) The contractor/processor may remove product cans from a lot or sublot suspected of containing defects after the x-ray examination and the balance of the lot or sublot may be reoffered for acceptance. Product containing defects may be reworked once.

7. Contaminated Commodity. A lot or sublot of commodity which contains foreign matter--for example, paper, plastic, rubber, or metal--will be handled in accordance with FSIS procedures. Samples which contain comminuted meat, giblets, or kidneys will result in rejection of the lot or sublot the samples represent.

8. Packing. All packing materials must be clean and in new condition and must not impart odors or flavors to the product.

a. Shipping containers

(1) Requirements. The shipping container must: (a) be a fiberboard container; (b) be of such size to pack the commodity without slack filling or bulging; (c) protect the commodity from contamination and against loss or damage; (d) withstand the variations in humidity and temperature during the conditions of use; and (e) have the combined facings weight, the bursting strength, and the compression strength (edge crush value) to withstand the stresses of handling, shipping, stacking, and storage.

(2) Container bottom. The flaps on the bottom of a shipping container must be securely fastened so the bottom remains securely fastened when the top of the container is opened.

(3) Final closure. Final closure of the shipping containers must be secure and made with commercially acceptable filament-reinforced tape, plastic film packaging tape, non-metallic strapping, adhesive, or other similar types of materials that are applicable for storage conditions and that provide for safe handling of the commodity. Steel or wire straps or staples must not be used for the final closure. Adhesive or staples cannot be used to fasten the top portion of telescope-style containers to the bottom portion. However, staples may be used to manufacture and to assemble the fiberboard shipping containers, provided the staples are fastened into the container and tightly clenched to eliminate sharp edges prior to packing the commodity into the shipping containers.

b. 29-ounce cans. Twenty-four 29-ounce (822-g) cans of commodity must be packed four in length, three in width, and on end in two layers in each shipping container.

c. 50-ounce cans. Twelve 50-ounce cans (1.42-kg) of commodity must be packed four in length, three in width, and on end in one layer in each shipping container.

II.

G. Laboratory Analyses

1. Fat Analyses.

a. Determination. The sample cans submitted for a lot or sublot will be combined by the USDA laboratory into a composite sample and analyzed in duplicate for fat. The analysis will be performed by the USDA laboratory. The USDA laboratory will report the results of each duplicate to nearest 100th of a percent and the average for each composite to the nearest 10th of a percent on the USDA certificate.

b. Chemical analyses and sample test portion size will be in accordance with the following methods found in the "Official Methods of Analysis," of the AOAC International, Seventeenth Edition, 2000, Chapter 39: "Meat and Meat Products," Subchapter 1, Sections 39.1.05, 39.1.06, and 39.1.07.

Finished Product	Test Method
Fat	Petroleum ether method or Rapid microwave -solvent extraction method

2. USDA Laboratories. The samples for laboratory analyses may be submitted to any one of the USDA laboratories listed below, except when AMS determines that the condition or workload of a specific laboratory does not permit the prompt handling of samples. All costs incurred for shipping the samples and the laboratory analyses will be paid by the contractor.

USDA, AMS, Science and Technology Programs
Eastern Laboratory
2311-B Aberdeen Boulevard
Gastonia, North Carolina 28054
Telephone (704) 867-3873

Laboratory Services Division
Minnesota State Department of Agriculture
90 West Plato Boulevard
St. Paul, Minnesota 55107
Telephone (651) 297-1901

Laboratory Services Division
Oregon Department of Agriculture
1207 Northwest Naito Parkway, Suite 204
Portland, Oregon 97209
Telephone (503) 872-6644

3. Timely Receipt of Laboratory Results. The contractor must present the thermal-processed commodity to USDA so the commodity may be sampled, the samples sent to the USDA laboratory, and the laboratory analyses performed in time for the laboratory results to be available for the contractor to meet the shipment or delivery requirements of the contract. If laboratory results are received by the contractor later than 7 calendar days, excluding Sundays and Federal Holidays, from the receipt of the samples by the USDA laboratory, the number of days' delay will be added to the permissible shipping or delivery period before liquidated damages for late shipment or delivery will be assessed.

4. Appeal of Laboratory Analyses. An appeal of an original laboratory analysis may be authorized for a lot or sublot of commodity. The appeal must be filed and made according to the appeal provisions in 7 C.F.R. part 70. Only one appeal per lot or sublot is permitted. In the event of an appeal, the following procedures will be used:

a. The USDA grader will randomly draw twice the number of original sample cans and identify the sample cans as appeal samples.

b. The appeal samples will be submitted to the USDA laboratory where the original analyses were performed.

c. The USDA laboratory will combine an equal number of consecutively numbered sample cans into two composite samples and analyze each composite sample. The results of each composite will be reported on the USDA certificate as outlined in II.G.1.a. and identified as the results for appeal samples.

d. The laboratory results of the appeal samples will supersede those of the original analysis being appealed. The results of the appeal will be final.

H. Contractor Analysis of Fat Content Program

As an alternative method of sampling and laboratory analyses detailed in section II.G., the contractor may elect to participate in the Contractor Analysis of Fat Content (CAFC) Program dated August 2001. AMS has developed this program to permit the use of contractor results to determine compliance with fat content requirements. Any questions about this program should be referred to the Contracting Officer at the following address:

Contracting Officer, Commodity Procurement Branch
Poultry Programs, AMS, U.S. Department of Agriculture
Room 3941-S, STOP 0260
1400 Independence Avenue, SW
Washington, D.C. 20250
Telephone: (202) 720-7693
Fax: (202) 720-5871

III. LABELING

A. USDA Labeling Requirements

1. Labeling Provisions. The USDA labeling information may be printed on a label, or embossed, printed, or lithographed on individual cans. All printed/labeled information must be water-fast, nonsmearing, of a contrasting color, clear, and readable. Any deviations from the USDA labeling requirements in this Specification must be approved by the Contracting Officer, in writing, prior to start of production.

2. Manufacturer Identification. The name, address, and phone number of the manufacturer must be shown on each can and shipping container.

3. Plant and Lot Number. The USDA-assigned plant number and lot number of the commodity must be embossed, stamped, or printed on each individual label/can or on one end of each can.

B. USDA Labeled Cans

1. Labeling Cans. Individual 29-ounce (822-g) cans must be labeled as shown in EXHIBIT 1, and individual 50-ounce (1.42-kg) cans must be labeled as shown in EXHIBIT 2.

2. Universal Product Bar Code.

a. A Universal Product Code (UPC), code and symbol, must appear on each can of commodity. The complete code, including the check digit, must be printed in machine-readable and human-readable form. The start and stop indicators must be included in the bar codes. Printing, readability, and scanability of the bar code must be in accordance with UPC guidelines published by Uniform Code Council, Inc., 7887 Washington Village Drive, Suite 300, Dayton, Ohio 45459.

b. The contractor must use the code furnished by USDA. USDA has acquired a unique manufacturer's identification number for the commodity purchase programs and will use a unique item code number for the commodities purchased under this Specification. The contractor need not join the Uniform Code Council, Inc.

c. The 12-digit UPC code for 29-ounce (822-g) cans of commodity is:
7 15001 01638 6

d. The 12-digit UPC code for 50-ounce (1.42-kg) cans of commodity is:
7 15001 01637 9

3. Nutritional Labeling. A nutritional label, indicating the nutrient content of the commodity, must be printed on each can of thermal-processed commodity.

a. This nutritional facts information or "nutrition facts panel" must be in compliance with applicable FSIS nutritional labeling requirements.

b. The nutrition facts panel must be legibly printed on the label of each can, or printed or lithographed on each can.

c. NOTE: The nutrition facts information and panel must be pre-approved by FSIS prior to shipment of the commodity. The method of providing and location of this information for each commodity can (labeled, printed, or lithographed) must be indicated on the FSIS label application. The pre-approved nutrition information must be provided to the USDA inspection personnel at the plant where the commodity is to be packed for shipment.

C. USDA Labeled Shipping Containers

1. Recycle Symbol and Statement. The contractor shall place somewhere on the surface of each recyclable shipping container the recycle symbol shown in EXHIBIT 3. The statement "PLEASE RECYCLE" is to be placed under the symbol. The recycle symbol and statement must be legibly printed in permanent ink.

2. Labeling and Marking Information.

a. Requirements. The labeling and marking information must be preprinted, stamped, or stenciled on shipping containers. This information, in essentially the same layout, is provided in EXHIBITS 4 and 5, "USDA Labeling Information for Shipping Containers of Chicken Chunks in Water" and "USDA Labeling Information."

b. "END" and "SIDE" designations. For the purpose of labeling and marking, the "end" and "side" panels may relate to the shortest and longest dimensions of the shipping container at the discretion of the contractor/processor. However, the panels must alternate between "end" panel and "side" panel designation with the two side panels and two end panels being located on opposite panels of the shipping container.

3. TOP PANEL - Labeling and Marking. The following information is required (as applicable) on the top panel of each shipping container:

a. Storing instructions. The following storing instructions must be printed on the top panel of each shipping container:

STORE UNOPENED CANS
IN A COOL, DRY PLACE

b. USDA symbol and manufacturer identification. The following must be printed on the "top panel" or the "one end" designated panel of each shipping container:

(1) The USDA symbol, copy on back of Specification, is to be a minimum of 2.25 inches (5.72 cm) in height.

(2) The manufacturer's name, address, and phone number.

III.C.

4. ONE END Panel - Labeling and Marking. The following information must appear (as applicable) on one end of each shipping container:

a. Type, name, ingredients statement, and legend. The following is required, and the words "Chicken Chunks in Water" must be printed in letters at least 1 inch (2.54 cm) high. The ingredients statement must be printed in accordance with FSIS regulations:

Fully Cooked
Chicken Chunks in Water
Ingredients:

Distributed by USDA in cooperation with State and local
or tribal governments for domestic food assistance programs.
Not To Be Sold Or Exchanged.

b. Contract number and pack date. The following information may be preprinted, stamped, or stenciled on the shipping container, or on a separate pressure-sensitive label:

(1) Last five digits of the contract number as it appears in the acceptance wire.

(2) Date packed (month, day, and year).

c. Inspection mark and plant number. The USDA inspection mark and USDA-assigned plant number must be printed on the "one end" designation panel of each shipping container.

d. Number and size of cans, and net weight. The number and size of cans, and the net weight statement must be printed on the "one end" designated panel of each shipping container:

(1) 29-ounce cans:

24/29-Ounce (822-g) cans
Net Weight: 43.50 LBS. (19.70 KG)

(2) 50-ounce cans:

12/50-Ounce (3-LBS. 2-Oz.) (1.42-KG) cans
Net Weight: 37.50 LBS. (17.01 KG)

e. Storing instructions. The following storing instructions must be printed on the "one end" designated panel of each shipping container:

Store Unopened Cans In A Cool, Dry Place

f. UPC code. A Universal Product Bar Code (UPC), bar and code, called the Interleaved 2 of 5 (I 2/5), must appear on the "one end" designated panel of each shipping container. See III.B.2. for more information.

(1) The 14-digit UPC code for shipping containers of commodity in 29-ounce (822-g) cans of commodity is: 1 07 15001 01638 3

(2) The 14-digit UPC code for shipping containers of commodity in 50-ounce (1.42-g) cans is: 1 07 15001 01637 6

g. USDA symbol and manufacturer identification. The following must be printed on the "one end" or the "top panel" designated panel of each shipping container:

(1) The USDA symbol, copy on back of Specification, is to be a minimum of 2.25 inches (5.72 cm) in height.

(2) The manufacturer's name, address, and phone number.

5. ONE SIDE Panel - Labeling and Marking. No labeling information is required on the side panel immediately to the right of the "one end" designated panel.

6. THE OTHER END Panel - Labeling and Marking. No labeling information is required on the end opposite the panel designated "one end."

7. THE OTHER SIDE Panel - Labeling and Marking. No labeling information is required on the side opposite the panel designated "one side."

8. Inventory Control Label. The processor may use a pressure-sensitive label to place any additional information (including bar codes) for processor inventory control purposes. This label may be applied somewhere on the surface of the shipping container. The label must not cover or conflict with the labeling requirements of this Specification.

D. F.a.s. Vessel Deliveries

F.a.s. vessel deliveries that are not source loaded in a seavan are required to show the final destination's overseas address as provided in the Notice to Deliver. The address must be clearly printed on at least two sides of each pallet.

IV. FINAL EXAMINATION OF PACKAGED AND PACKED COMMODITY

A. Verification of Materials and Defects

1. Verification of Packaging and Packing Materials.

The contractor must verify compliance with packaging, packing, and marking material requirements by furnishing the USDA grader the following certification on company stationery signed by a person authorized to do so by the contractor:

> "(I) (We) certify that the packaging, packing, and marking materials used for any commodity presented for acceptance under the terms of the Commodity Specification for Chicken Chunks in Water, dated January 2002, comply or will comply with the terms of this Commodity Specification.
>
> Name _____
>
> Title _____"

One certification is adequate for all production under this Specification.

2. Container, Labeling, and Marking Defects.

a. Defects. Cans and shipping containers will be examined for container, labeling, and marking defects in accordance with the United States Standards for Condition of Food Containers and the USDA publications "Procedures for the Inspection of the Condition of Food Containers" and "Visual Aids for Inspection for Metal Containers."

b. Tolerance for defects. If samples of packaged commodity or the shipping containers in a delivery unit have more defects than the maximum tolerance for the applicable Poultry Programs' sample plan, the delivery unit will be rejected.

B. Inspection and Checkloading

1. Requirements. Inspection for contract compliance will be made by a USDA representative, in accordance with 7 C.F.R. part 70, FSIS regulations, and this Specification, at site of processing, both during and after processing and packaging. A USDA representative may select samples for laboratory analyses or inspect the commodity at any point in transit and after delivery to point of destination. Inspection records must be complete and made available to USDA, as requested, to assure contract compliance.

2. Procedures. The inspection and checkloading required by Articles 54 and 55 of USDA-1 must be performed by the USDA grader. Procedures to be followed and a schedule of fees for these services may be obtained by contacting the nearest Grading Branch field office or the Chief of Grading Branch, Poultry Programs, AMS, USDA, Room 3938-S, STOP 0258, 1400

Independence Avenue, SW, Washington, D.C. 20250-0258, telephone (202) 720-3271. The quality, quantity, weight, packaging, packing, and checkloading of the commodity must be

evidenced by USDA certification. The contractor must not ship the commodity unless informed by the USDA grader that the designated lot or sublot to be shipped meets contract specifications.

V. UNITIZATION

Each delivery unit of commodity must be unitized (palletized and stretchwrapped) and comply with the following:

A. Pallets

Pallets must be good quality, wood, 48 inches x 40 inches, nonreversible, flush stringer, and partial fourway entry. Each pallet of shipping containers must be stretchwrapped with plastic film in a manner that will secure each container and layers of containers on the pallet. Palletized product must be loaded in a way that will prevent shifting and damage to containers of product.

B. Pallet Exchange

Contractors may arrange for pallet exchange with consignees; however, USDA is in no way responsible for such arrangements.

VI. SHIPMENT AND DELIVERY

Shipment and delivery must be made in accordance with this Specification, the applicable Announcement and Invitation, and Articles 56, 57, and 64 of USDA-1, as amended by the Announcement. In addition, the contractor must adhere to the following provisions:

A. Contract Compliance Stamp

Each shipping container must be identified with a USDA Contract Compliance stamp with the applicable certificate number. A USDA grader, or other authorized personnel under the supervision of the USDA grader, will stamp one end of each shipping container prior to shipment. If there is inadequate space available on either end of the shipping container, the stamp may be applied to a side of the container.

B. Grading Certificate

A copy of the original USDA Poultry Products Grading Certificate issued at time of checkloading must accompany each shipment.

1. Railcar or Piggyback. If shipment is by rail or piggyback, the certificate must be placed in the railcar or trailer for easy access to the USDA grader, warehouseman, or consignee, as applicable.

2. Trucks. If shipment is by truck, the driver must, upon delivery, give the certificate to the USDA grader, warehouseman, or consignee, as applicable.

VI.

C. Loading and Sealing of Vehicles

Loading must be in accordance with good commercial practices and the sealing must be done at origin under the supervision of a USDA grader.

1. Railcar. Each railcar must be sealed. The contractors are responsible for arranging railcar deliveries of more than one delivery unit so that each delivery unit contained in the same railcar can be completely separated and sealed.

2. Truck or Piggyback. Truck or piggyback shipments must be sealed at origin. A delivery unit shipped by truck or piggyback which includes split deliveries to two destinations will not require separation by sealing each drop.

D. Delivery Notification

Notwithstanding the provisions of Article 56(c) of USDA-1, as amended by the applicable Announcement, the contractor must follow the instructions in the Notice to Deliver issued by the Kansas City Commodity Office (KCCO) concerning delivery notification. Such notification and information of impending delivery are vital in proper execution of delivery. The contractor must notify the State distributing agency and the consignee of shipment per instructions in the Notice to Deliver. For rail or piggyback shipments, notification shall be made on the day of shipment. For truck shipments, notification of the estimated arrival time should be made as far in advance of delivery as possible. In addition, for truck or piggyback shipments, the contractor must request and keep scheduled appointment(s). Unloading appointments for truck or piggyback shipments must be requested from the consignee contact party(ies) at least 24 hours in advance of delivery.

1. In-Plant Deliveries. When in-plant delivery is made, the contractor must notify the appropriate resident USDA grader and furnish applicable information.

2. Delivery In Storage. Delivery may be made in store provided the destination in the Notice to Deliver and the place the contractor has the commodity in storage are the same. Inspection and certification by a USDA grader are also required for transfers in store.

3. Early Delivery. The contractor may deliver early upon approval of the KCCO. Approval may be obtained by telephoning (816) 926-6068. Approval is contingent on the recipient's concurrence to accept early delivery and upon the USDA grader being available to perform necessary checkloading and final acceptance duties.

E. Split Deliveries

The contractor is responsible to deliver the quantity stated on each Notice to Deliver to each destination. Contractors must provide to the USDA Grader, at time of shipment, the number of boxes and pounds for each destination.

At the option of the contractor, a purchase unit with two Notices to Deliver (split deliveries) for two different destinations may be delivered on two separate trucks provided each truck ships the total quantity stated on the Notice to Deliver. Any additional costs will accrue to the contractor's account.

Howard M. Magwire
Deputy Administrator, Poultry Programs

Attachment

EXHIBIT 1
USDA Labeling Information for 29-Ounce Cans

<u>Marking Information</u>: Twenty-nine ounce (822-g) cans of Chicken Chunks in Water must be marked as shown below. Markings must be legibly labeled, printed, embossed, or lithographed on cans. The name, address, and phone number of the manufacturer must be shown on each can. The names of ingredients and the UPC 12-digit code (7 15001 01638 6), bar and code, must be shown on each can. The plant and lot number must be embossed, stamped, or printed on each can or on one end of each can.

Chicken Chunks in Water	Chicken Chunks in Water
Ingredients: **Distributed by USDA in cooperation with State and local or tribal governments for domestic food assistance programs. Not To Be Sold Or Exchanged.** USDA U.S. DEPARTMENT OF AGRICULTURE FOOD ★★★	**Chicken Chunks In Water Is Fully Cooked And Ready to Eat.** **Store unopened cans in a cool, dry place.** **Nutrition Facts Panel May Be Placed Here.** **Plant and Lot Number** **Manufacturer's Name, Address, and Phone** **UPC Bar and Code**

 **Net Weight: 29 ounces (822 g)**	

EXHIBIT 2
USDA Labeling Information for 50-Ounce Cans

<u>Marking Information</u>: Fifty-ounce (1.42-kg) cans of Chicken Chunks in Water must be marked as shown below. Markings must be legibly labeled, printed, or lithographed on cans. The name, address, and phone number of the manufacturer must be shown on each can. If a label is used, it must be a wraparound type which is at least 6 inches (15.24 cm) in height. The names of ingredients and the UPC 12-digit code (7 15001 01637 9), bar and code, must be shown on each can. The plant and lot number must be embossed, stamped, or printed on each can or on one end of each can.

Chicken Chunks in Water

Ingredients:

Distributed by USDA in cooperation with State and local or tribal governments for domestic food assistance programs. Not To Be Sold Or Exchanged.

USDA
U.S. DEPARTMENT OF AGRICULTURE
FOOD
★★★

INSPECTED FOR WHOLESOMENESS BY U.S. DEPARTMENT OF AGRICULTURE P-00

Chicken Chunks in Water

Chicken Chunks In Water Is Fully Cooked And Ready to Eat.

Store unopened cans in a cool, dry place.

Nutrition Facts Panel May Be Placed Here.

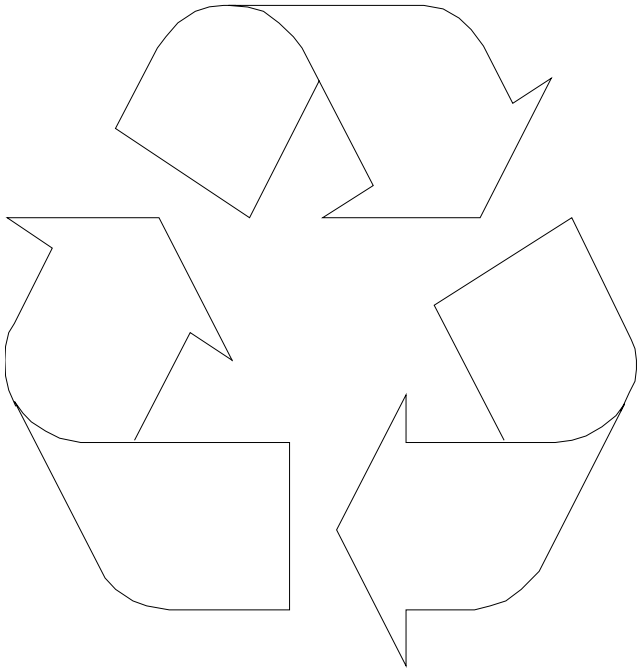
Plant and Lot Number

Manufacturer's Name, Address, and Phone

UPC Bar and Code

Net Weight: 50 ounces (3 lbs. 2 oz.) (1.42 kg)	

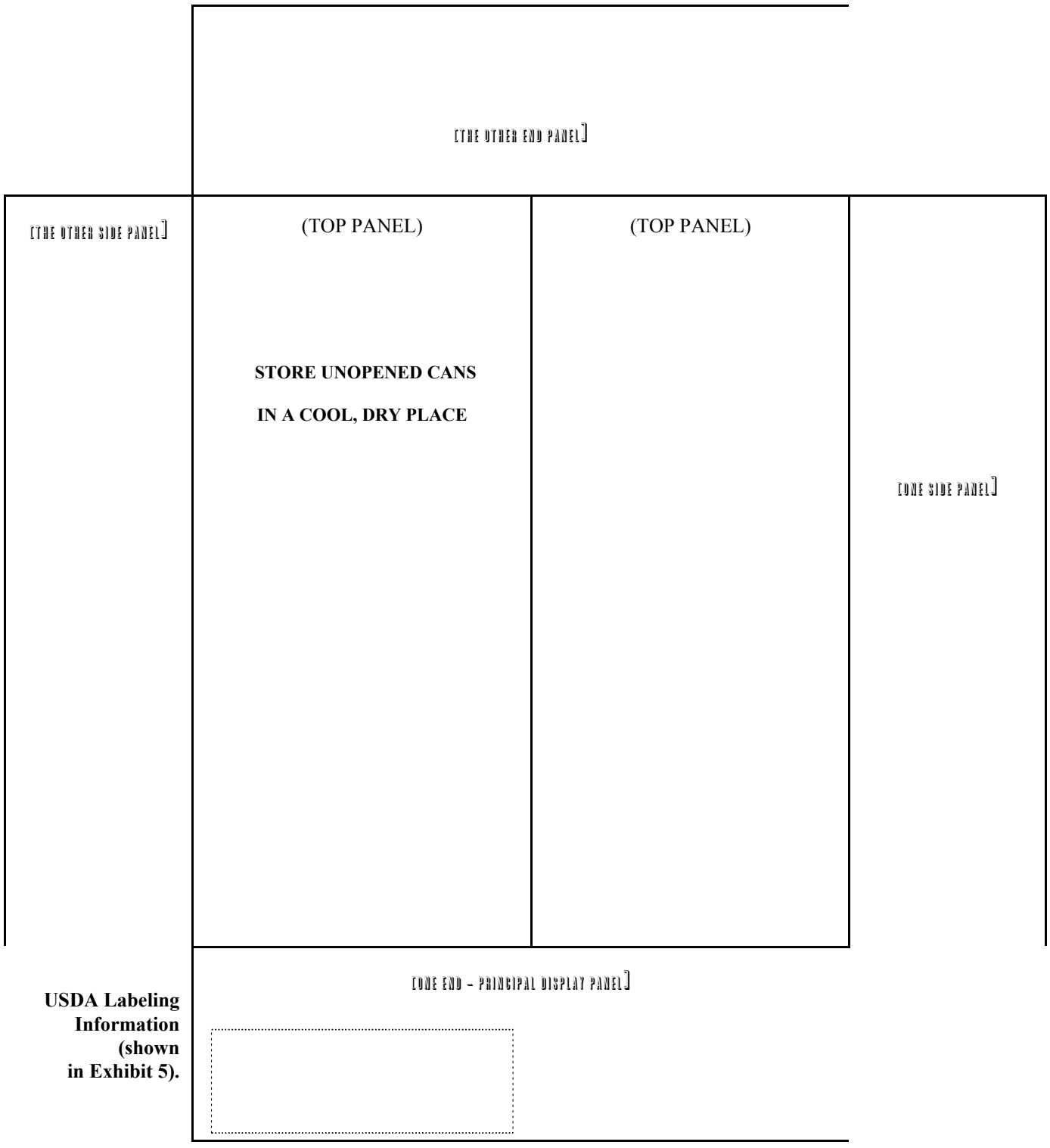
EXHIBIT 3
"Please Recycle" Symbol and Statement



PLEASE RECYCLE

EXHIBIT 4
USDA Labeling Information for Shipping Containers of Chicken Chunks in Water

<u>Marking Information</u>: Shipping containers shall be marked substantially as shown below. Markings must be preprinted, stamped, or stenciled on containers, water-fast, nonsmearing, of a contrasting color, clear, and readable. The USDA symbol is to be a minimum of 2.25 inches (5.72 cm) in height and may be printed on the "TOP PANEL" or "ONE END" designated panel. The manufacturer's name, address, and phone number may be printed on the "TOP PANEL" or "ONE END" designated panel.



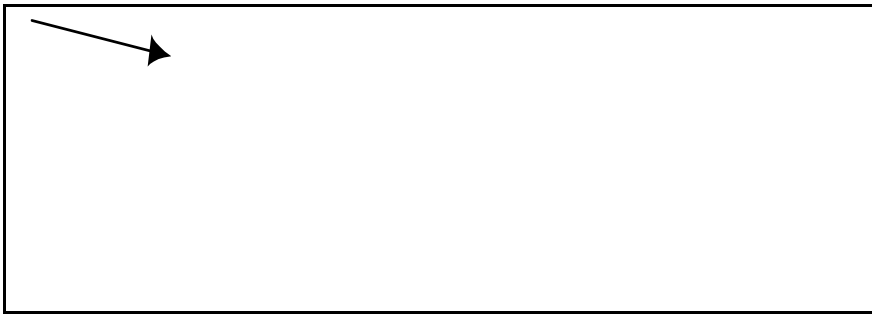


EXHIBIT 5
USDA Labeling Information

Marking Information: USDA labeling information must be printed on the "ONE END" panel of each shipping container as provided in Exhibit 4. Markings must be preprinted, stamped, or stenciled on containers, water-fast, nonsmearing, of a contrasting color, clear, and readable. The words "CHICKEN CHUNKS IN WATER" must be printed in letters 1-inch (2.54-cm) high. The USDA symbol must be a minimum of 2.25 inches (5.72 cm) in height and may be printed on the "TOP PANEL" or "ONE END" designated panel. The manufacturer's name, address, and phone number may be printed on the "TOP PANEL" or "ONE END" designated panel.

Fully Cooked
CHICKEN
CHUNKS IN WATER

Ingredients:

Distributed by USDA in cooperation with State and local or tribal governments for domestic food assistance programs. Not To Be Sold Or Exchanged.

Manufacturer's
Name, Address, and Phone

Store Unopened Cans In A Cool, Dry Place

☐ **24/29-Ounce (822-g) Cans**
Net Weight 43.50 LBS. (19.70 KG)
OR
☐ **12/50-Ounce (3 LBS. 2-Oz.) (1.42-KG) Cans** **CONTRACT NO.**

Net Weight 37.50 LBS. (17.01 KG) **DATE PACKED Month, Day, and Year**

UPC Bar and Code

USDA SYMBOL